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(51) INT CL<sup>6</sup>

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A6S S1F1 S1F6

(56) Documents Cited

GB 1518830 A

GB 1294637 A

GB 0835088 A

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US 3783554 A

(58) Field of Search

UK CL (Edition P) A6S

INT CL<sup>6</sup> A63H

ONLINE:WPI

(54) Dolls clothing

(57) A doll's garment is moulded from an elastomeric material or rubber, to give greater realism. A set comprising a miniature doll with articulated limbs and at least one garment therefor is also provided. Suitable elastomeric materials are polyvinyl chloride, ethylene vinyl acetate co-polymers, styrene containing co-polymers and low density polyethylene. The garment may be injection moulded and may have detail such as belt, button or collar integrally moulded therewith.

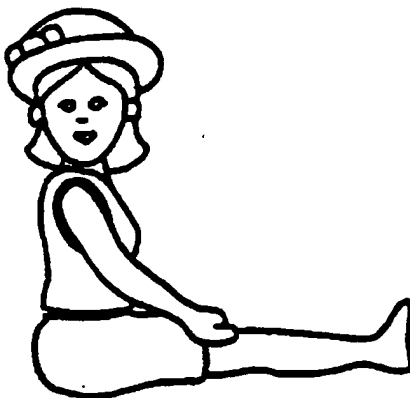


Fig. 3e

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Fig. 1a



Fig. 1b



Fig. 1c

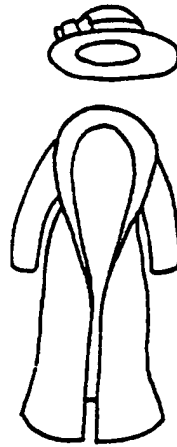


Fig. 1g



Fig. 1d

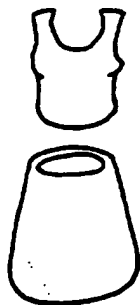


Fig. 1e



Fig. 1f

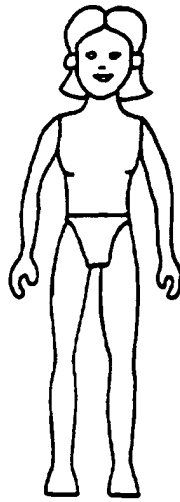


Fig. 2a

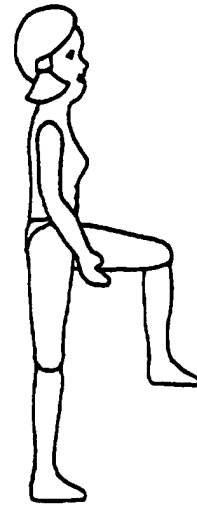


Fig. 2b



Fig. 2c

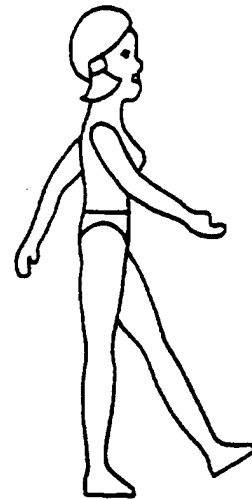


Fig. 2d

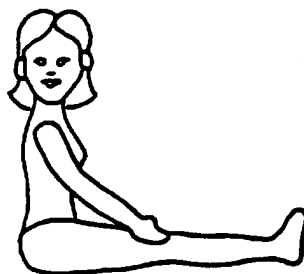


Fig. 2e

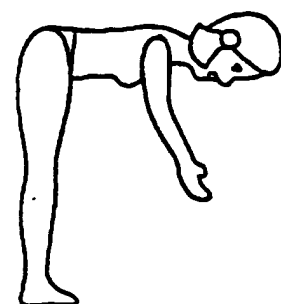


Fig. 2f

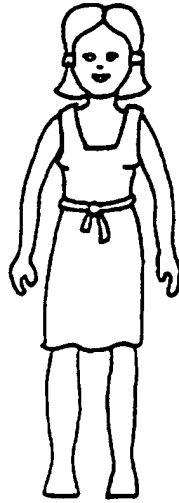


Fig. 3a

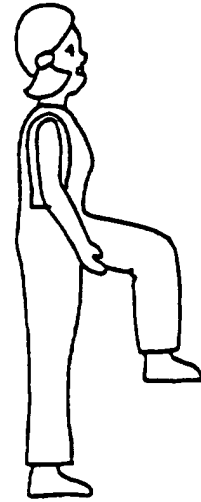


Fig. 3b



Fig. 3c



Fig. 3d

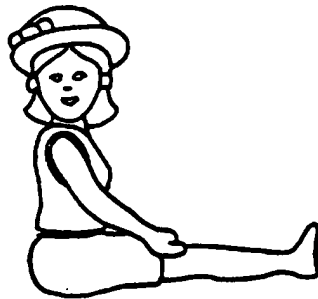


Fig. 3e

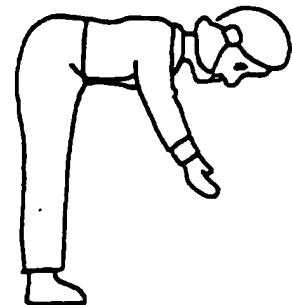


Fig. 3f

DOLL'S CLOTHING

The present invention relates to a doll's garment, a method for the manufacture thereof and to a set comprising a doll and at least one garment therefor.

5       Traditionally, doll's clothes are stitched from fabric, but this is impracticable for making clothes for dolls smaller than about 8cm in height, due to the difficulty experienced in forming the stitches.

10       Various proposals have therefore been advanced for making articles simulating doll's clothing from alternative materials. For example, US-A-4414774 describes fabricating such articles from plastics materials. The articles are said to be "semi-rigid or flexible" but in practice their degree of rigidity is such that they lack realism and appear  
15 bulky, cannot be fitted or removed in a life-like manner and are restricted to dolls of a particular shape. In addition, once the doll is clothed, its limbs cannot be moved so that the articles are unsuitable for dolls with articulated limbs.

20       In order to overcome at least some of these disadvantages, from a first aspect, the present invention provides a doll's garment made from an elastomeric material or rubber.

25       The material may in particular be selected from poly (vinyl chloride) (PVC), ethylene vinyl acetate copolymer (EVA), any of the polymers sold under the trade mark "Kraton" by Shell Chemical Co (such as (optionally hydrogenated) styrene-butadiene-styrene, styrene-isoprene-styrene, styrene-diene, styrene-isoprene and styrene-  
30 butadiene block copolymers, styrene-ethylene-butylene block copolymer containing mineral oil, branched styrene copolymer, styrene-butadiene rubber, styrene-butadiene triblock rubber, styrene-isoprene-styrene linear block

polymer, styrene-butadiene radial block copolymer, butadiene-styrene copolymer rubber, or synthetic rubber) and low density polyethylene (LDP). Preferably, the average modulus of elasticity of the material is less than  $1 \text{ MNm}^{-2}$ .  
5 More preferably, the 100% modulus of elasticity, measured at a standard test speed of 500mm/min, is between 120 and 350  $\text{kNm}^{-2}$ , and still more preferably between 240 and 280  $\text{kNm}^{-2}$ . The 300% modulus of elasticity may lie between 440 and 490  $\text{kNm}^{-2}$ . Such values provide a material from which garments  
10 with sufficient realism can be moulded, whilst avoiding increased difficulty in moulding detail and in removal of the moulded garments from the mould which the inventors have found to occur with highly elastic polymers.

Advantageously, the wall thickness of the garment is  
15 from 1 to 3mm.

From a second aspect, the present invention provides a method of manufacturing a doll's garment, comprising moulding an elastomeric material or rubber. Preferably, the garment is injection moulded, but it may alternatively  
20 be dip moulded. The material may in particular be selected from those listed above.

From a third aspect, the invention provides a play set comprising a doll having articulated limbs and at least one garment for the doll, the or each garment being made from  
25 an elastomeric material or rubber.

The doll is preferably articulated at the shoulders and hips and may additionally be articulated at the elbows and/or the knees. The doll may be less than 8cm in height and in a particular embodiment, the doll is approximately  
30 4cm in height.

The invention will now be described, by way of example only, with reference to the accompanying drawings, in which:-